

Date: Monday, 2/27/2006 4:17:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING ANGLE		
Job Number	: 25970					
Estimate Number	: 10509					
P.O. Number	: N/A		Part Number	: D2564		
This Issue	: 2/27/2006 S.O. No. : N/A		Drawing Number	: D2564 REV. B1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B1		
Previous Run	: N/A		Material	: N/A		
Written By	: See Comment Below		Due Date	: 3/20/2006 Qty: 50 Um: Each		
Checked & Approved By	: CKD 06.02.28					
Comment	: Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF					

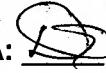
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6207	Angle Extrusion 1x1x.125		
		Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s)		
		Angle Extrusion		
		Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)		
		(D6207) Batch: B24248		
			<i>ml 06/04/06</i>	<i>52</i>
2.0	BAND SAW	BAND SAW		
		Comment: BAND SAW		
		Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)		
			<i>ml 06/04/06</i>	<i>52</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1		
		Machine as per Folio FA276 and Dwg D2564		
		Tumble and Deburr		
		Identify as D2564		
			<i>ml 06/04/06</i>	<i>52</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
			<i>ml 06/04/06</i>	<i>52</i>
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		
			<i>ml 06/04/06</i>	<i>52</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 25970

Part Number: D2564

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA#3

AE 06.04.07 52

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

52 06/04/10

Job Completion



U 06.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

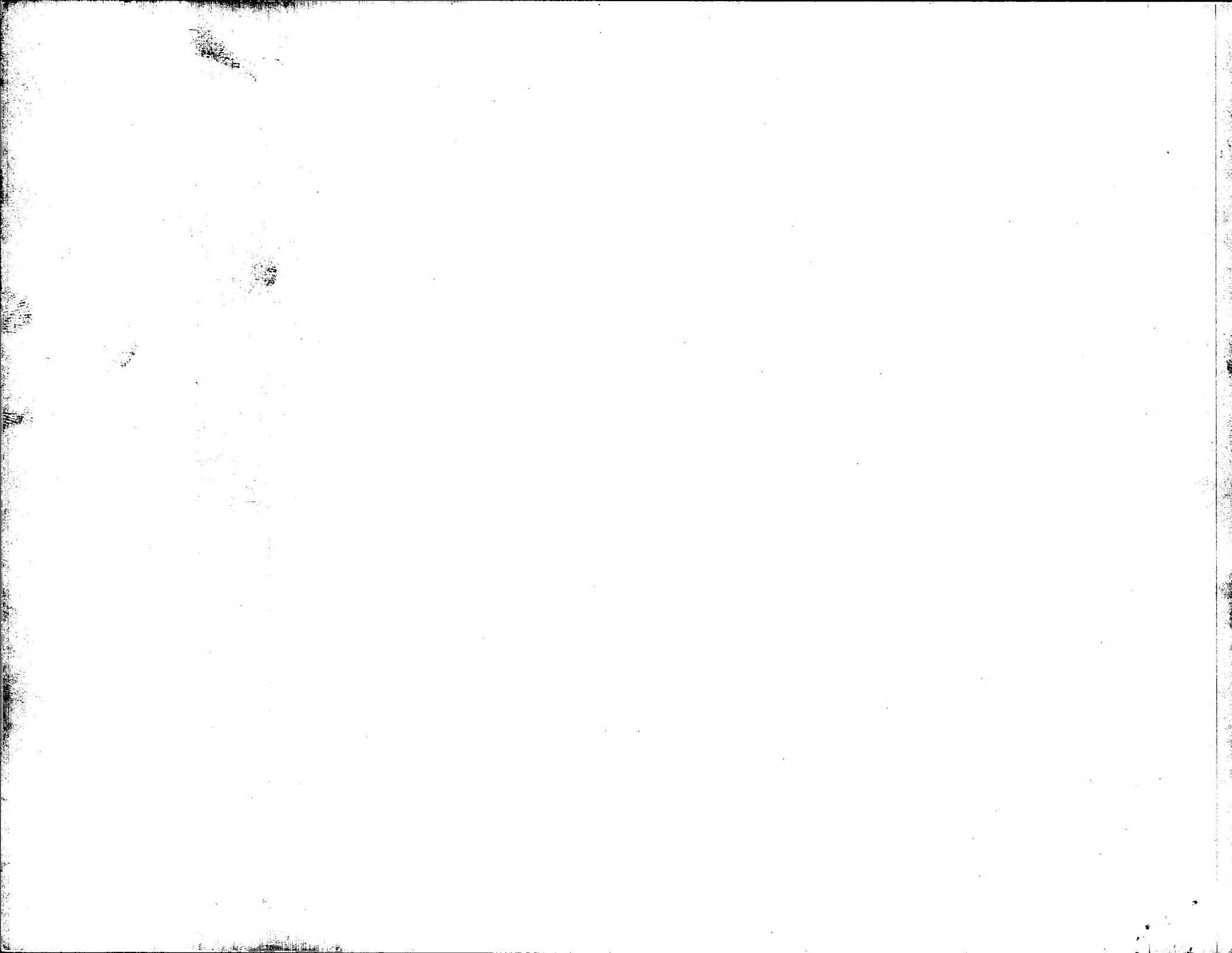
DART AEROSPACE LTD	Work Order:	25910
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

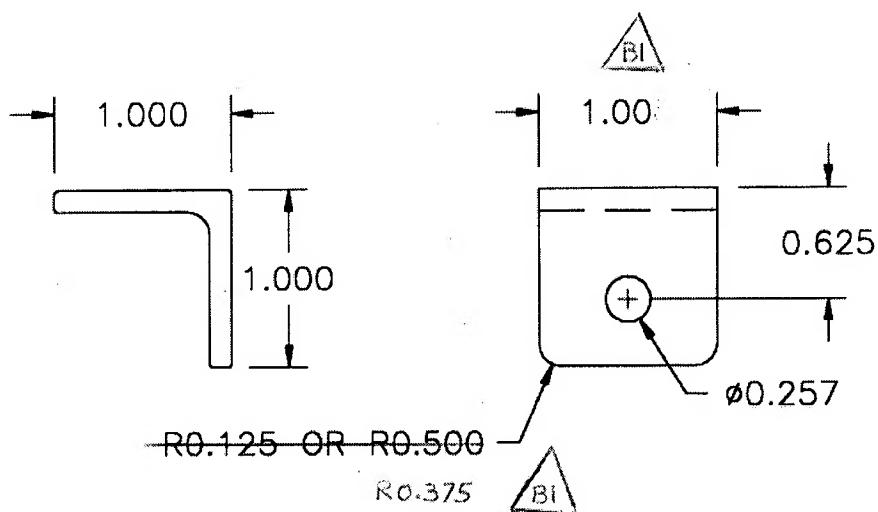
Measured by:	<i>JNL</i>	Audited by:	<i>M8</i>	Prototype Approval:	N/A
Date:	06/04/06	Date:	06/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue	KJ/JLM	



DART

DESIGN MIKE M	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED BW	APPROVED BW	DRAWING NO. D2564
DATE 96:04:30		REV. B SHEET 1 OF 1
		TITLE MOUNTING ANGLE
		SCALE 1:1
B	97:05:06	MODIFIED DIMENSIONS
BI	RF 02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000

RELEASED
(97/05/06 BW)NOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25970